

Date: Wednesday, 8/15/2007 3:20:04 PM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CONSOLE BRACKET HI-SLOPE
Job Number	33908		
Estimate Number	11004		
P.O. Number	N/A	Part Number	D2606
This Issue	8/15/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2606 REV A1
First Issue	N/A	Project Number	N/A
Previous Run	31334	Drawing Revision	A1
Written By	<i>JL 07-08-15</i>		
Checked & Approved By			
Comment	Est. D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM		

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S040	2024-T3 .040 sheet 
Comment: Qty.: 0.1582 sf(s)/Unit Total : 3.1647 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick Stack of 10 (M2024T3S.040) Batch <u>M105225</u> <i>HB07-08-15</i>		

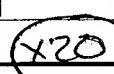
2.0	WATER JET	FLOW WATER JET 
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Comment: FLOW WATER JET 1-Cut as per Dwg D2606 Dwg Rev: <u>A1</u> <i>HB 07-08-15</i>  Prog Rev: <u>A1</u>		
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3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE 2-Deburr if necessary <i>SAP 07/08/16</i>  QC2 <i>HB 07-08-15</i> 		
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4.0	QC8	SECOND CHECK 
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Comment: SECOND CHECK <i>HB 07/08/15</i>  counter		
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 33908

Part Number: D2606

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr 3A0 07/08/16 20

Form as per Dwg D2606

8B 07/08/17 20

6.0 QC5 INSPECT WORK TO CURRENT STEP



Counters

Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20 20

X20

Q20

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-f

07/08/22

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C20 07/08/22 20

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/23 20

10.0 QC21 FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion

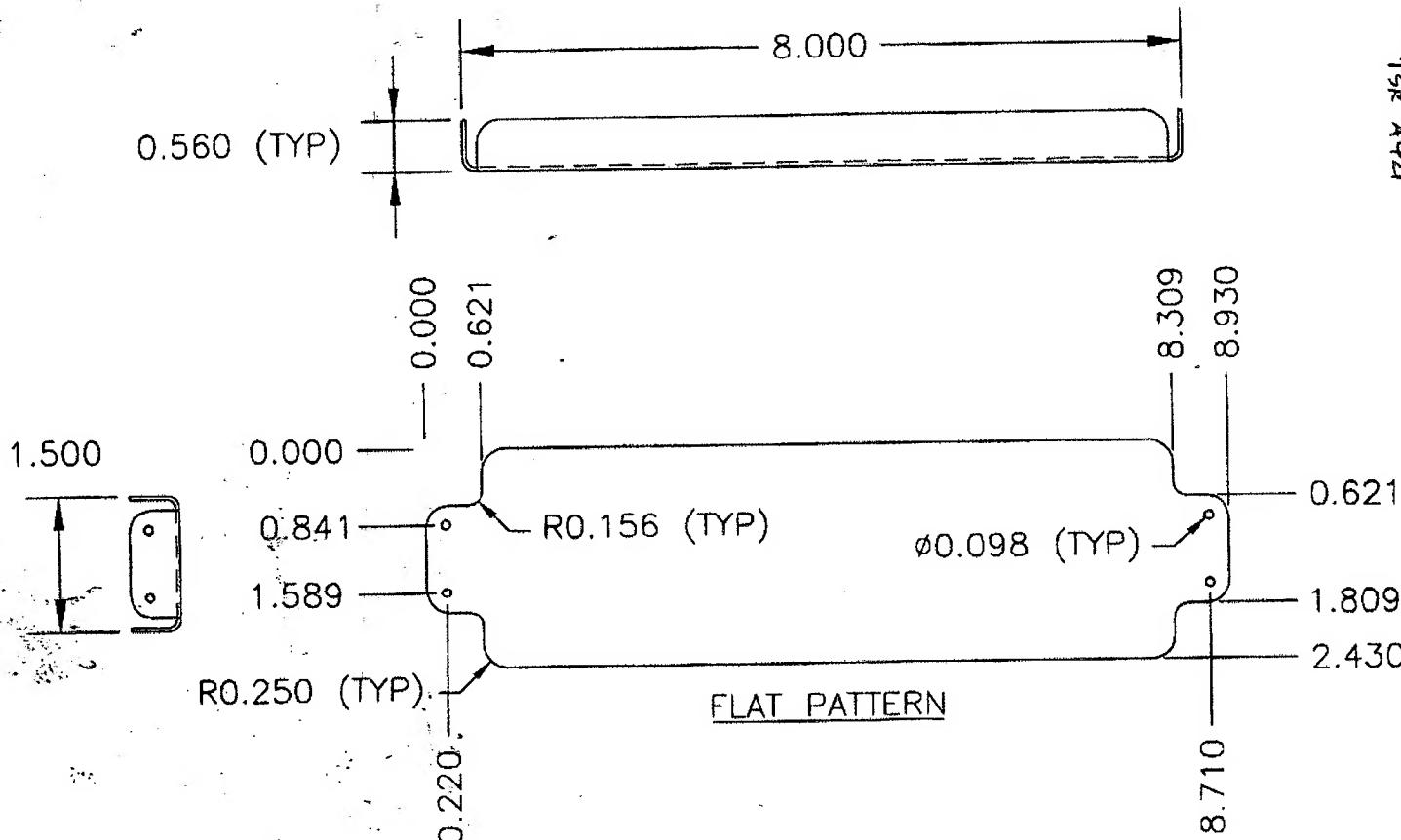


W 07/08/24



RELEASE
97.11.04 KE
TSR A424

DESIGN <i>K</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD	
		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>K</i>	APPROVED <i>J</i>	DRAWING NO. D2606	SHEET 1 OF 1
DATE 97.10.23	TITLE CONSOLE BRACKET		SCALE 1:2
A <i>CP</i>	97.10.23 D2606 WAS D206-547-27		REV. A
A1 <i>CP</i>	02.06.04 ADD FINISH		



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART Q51 065 4.1 **AI**

DART AEROSPACE LTD	Work Order:	33808
Description: Console Bracket	Part Number:	D2606
Inspection Dwg: D2606	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	EJ	Prototype Approval:	N/A
Date:	07-08-15	Date:	07/08/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>